

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-197** Date Opened: **17 Nov. 17** Title: **Assembly**Aircraft OEM: **Bell** Aircraft Model: **407** Product Type: **Cargo Basket** Product Model: **High Ski** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
JC
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
76610	1	Basket	CB/JC
76627	1	Placard	CB/JC
70405	4	Lid Walkway	CB/JC
84255	2	Handle Installation	CB/JC
84240	0	Lid Brace Installation	CB/JC

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

CB/JR
CB/JR
JR
JR
JR
JR
CB/JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: C. Brander J RekveSign: SCA: AD01Date: 22-Nov-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 22-Nov-17

Work Order closed by:

Print: C. Brander J. ClarkeSign: SCA: AD02Date: 23-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Aerospace Bandy Machining

Color:

N/A

WO#:

N/A

PO# 17017



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle Assy

No. of pieces: 1

Manufacturer: Aero Design

Part No.: 84261-01

Serial/Batch No.: N/A

TTSN: NP

TSO: N/A

Rem.: N/A

Work Order No.: 2017-194

Remaining Tasks to be Performed: To be installed.

Signature: David Martz

Date: Nov 21/2017

Lic. No. / SCA

AD  
73-04  
05

Serviceable



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: Tread Plate

Aircraft: All Model: N/A

Description: Lid Walkway Checker Plate

Supplier: Ryerson

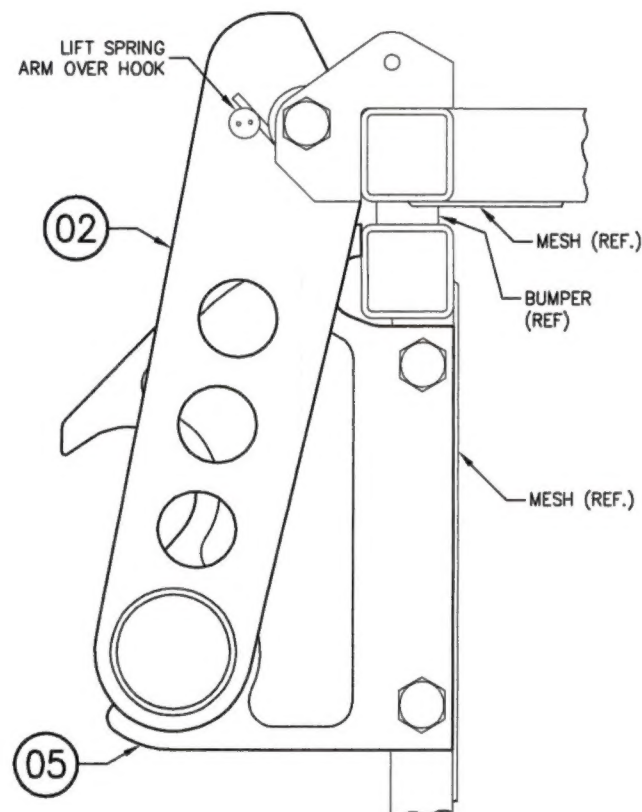
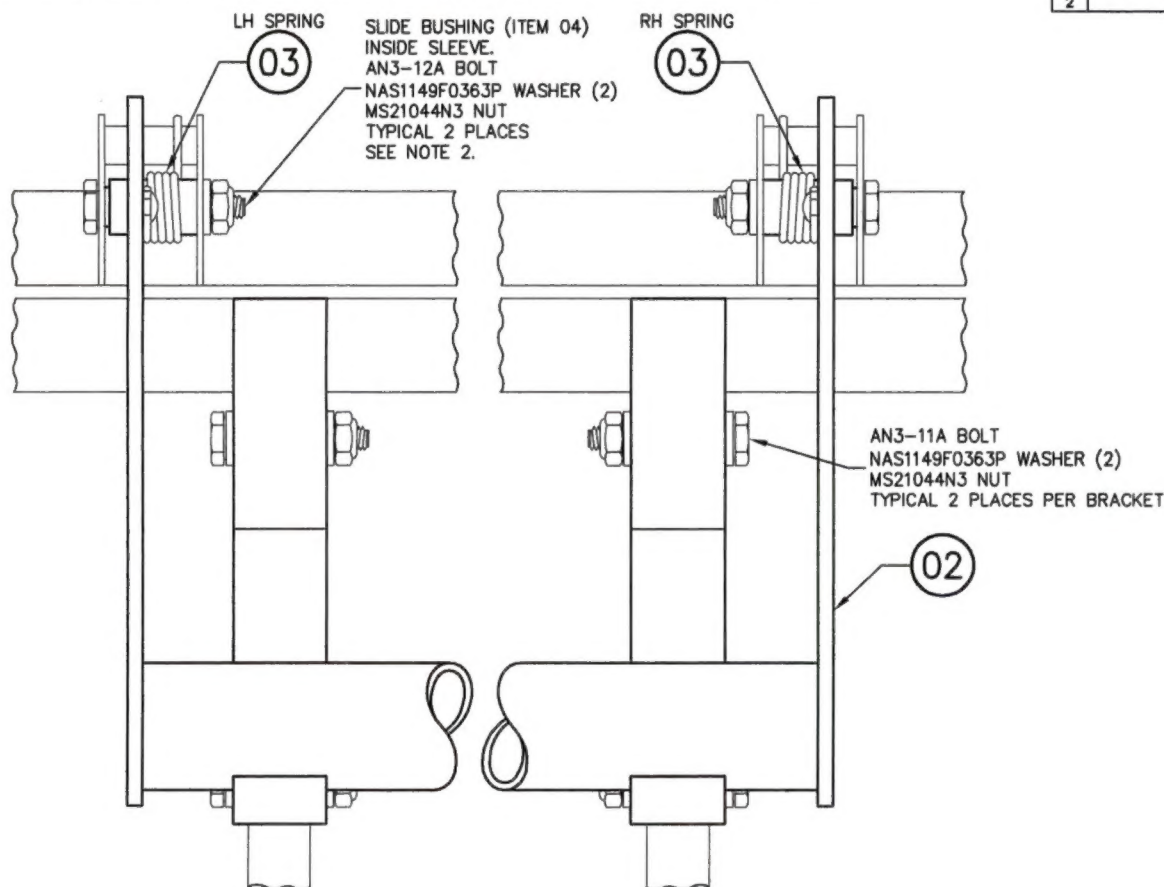
Color: Aluminum

WO#: N/A

PO# 17081

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G5  
TEL: 604.483.2376 www.aerodesign.ca

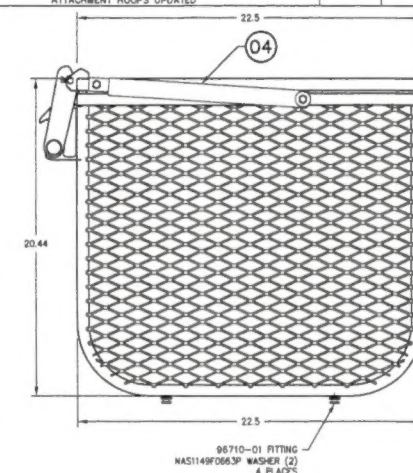
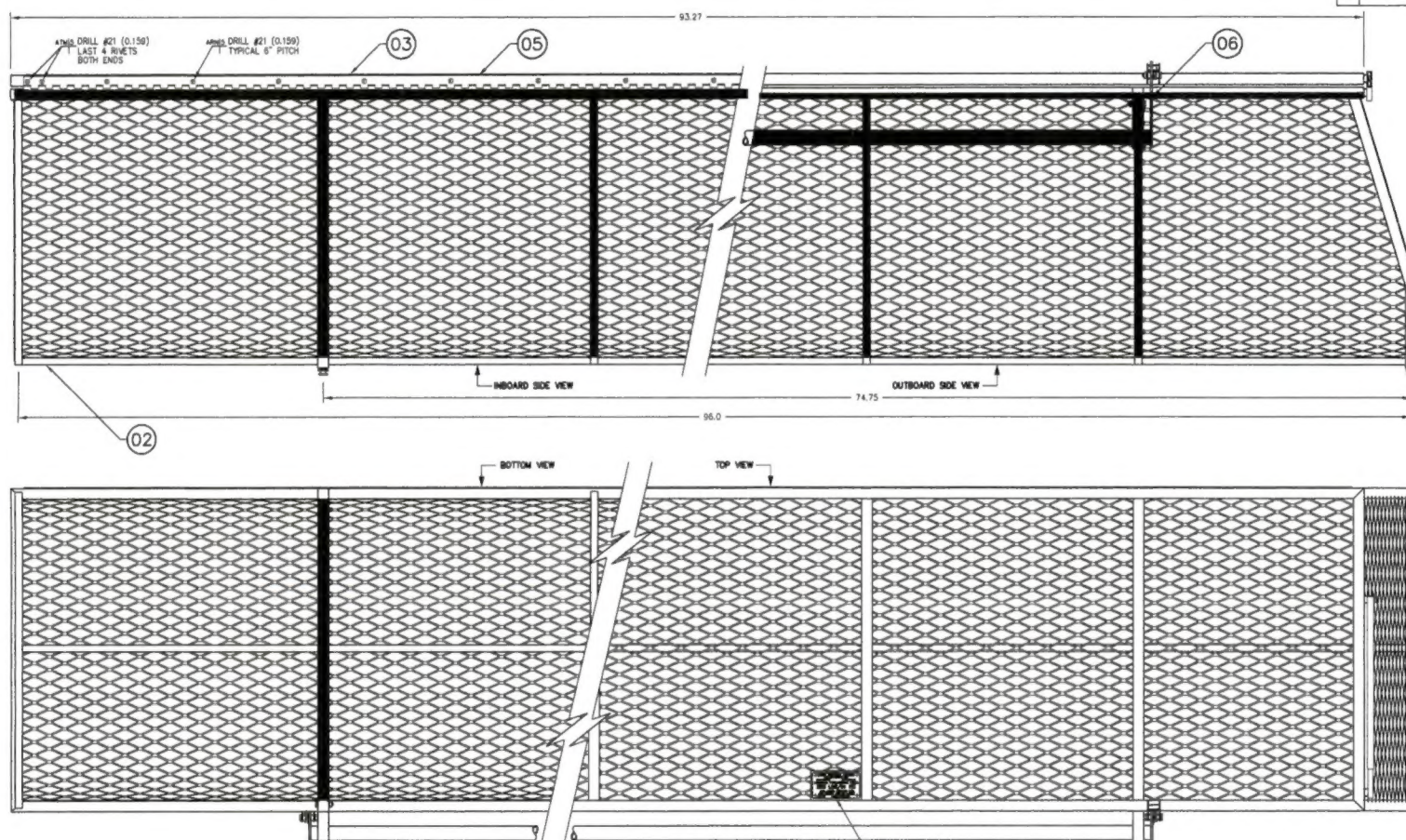
**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



2017-197

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 60030	BJC	25/09/2007
1	STILE BLOCK UPDATED - HANDLE UPDATED TO 842 CONFIGURATION	BJC	25/09/2007
2	PLACARD UPDATED AND MOVED TO OPPOSITE SIDE; HARDWARE UPDATED	BJC	25/09/2007
3	ATTACHMENT HOOPS UPDATED		

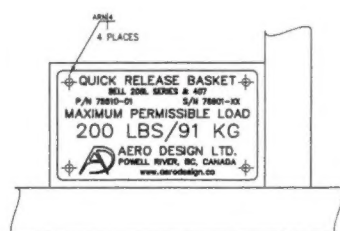


NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY.	PART NO.	ITEM	DESCRIPTION	MATERIAL
4	CR3213-4-02	CHERRY RIVET	AL.T. HR3213-4-02	
8	CR3523-5-02	CHERRY RIVET	AL.T. HR3523-5-02	
A/R	CR3213-5-02	CHERRY RIVET	AL.T. HR3213-5-02	
8	NAS1149F0663P	WASHER	AL.T. ANCR4 40688-14	
4	96710-01	FITTING	ARGUS INDUSTRIES	
4	49205-14	08 BUMPER		
1	76627-01	07 PLACARD		
1	84255-01	06 HANDLE BAR INSTALLATION		
1	MS20001P4	05 PLANO HINGE	90 INCHES	
1	84240-01	04 BRACE INSTALLATION		
1	60632-01	03 LID ASSEMBLY		
1	76611-01	02 BASKET BODY ASSEMBLY		
1	76610-01	01 CARGO BASKET ASSEMBLY		

# LIST OF MATERIALS

BASIC CODE REF. NAS 523		DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKE 25 SEPT 2007 CHECKED: E. BURGON 27 SEPT 2007		DATE 27 SEPT 2007		AERO DESIGN LTD. 9808A MALAYSIA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604-683-2970 www.aerodesign.ca	
C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.		BELL 407, 206L SERIES QUICK RELEASE HIGH MOUNTED CARGO BASKET CARGO BASKET ASSEMBLY		REV	
BASIC CODES: BJ = MS20470AD BS = MS20426AD ARN = CR3213 ATM = CR3523		+ ⊕ INSTALL NEW RIVET + ⊕ REMOVE/REPLACE RIVET - ⊕ EXISTING RIVET		TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		SCALE 1 : 4 SHEET 1 OF 1		DWG NO A1 76610	



DETAIL B

SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

BUMPER INSTALLATION

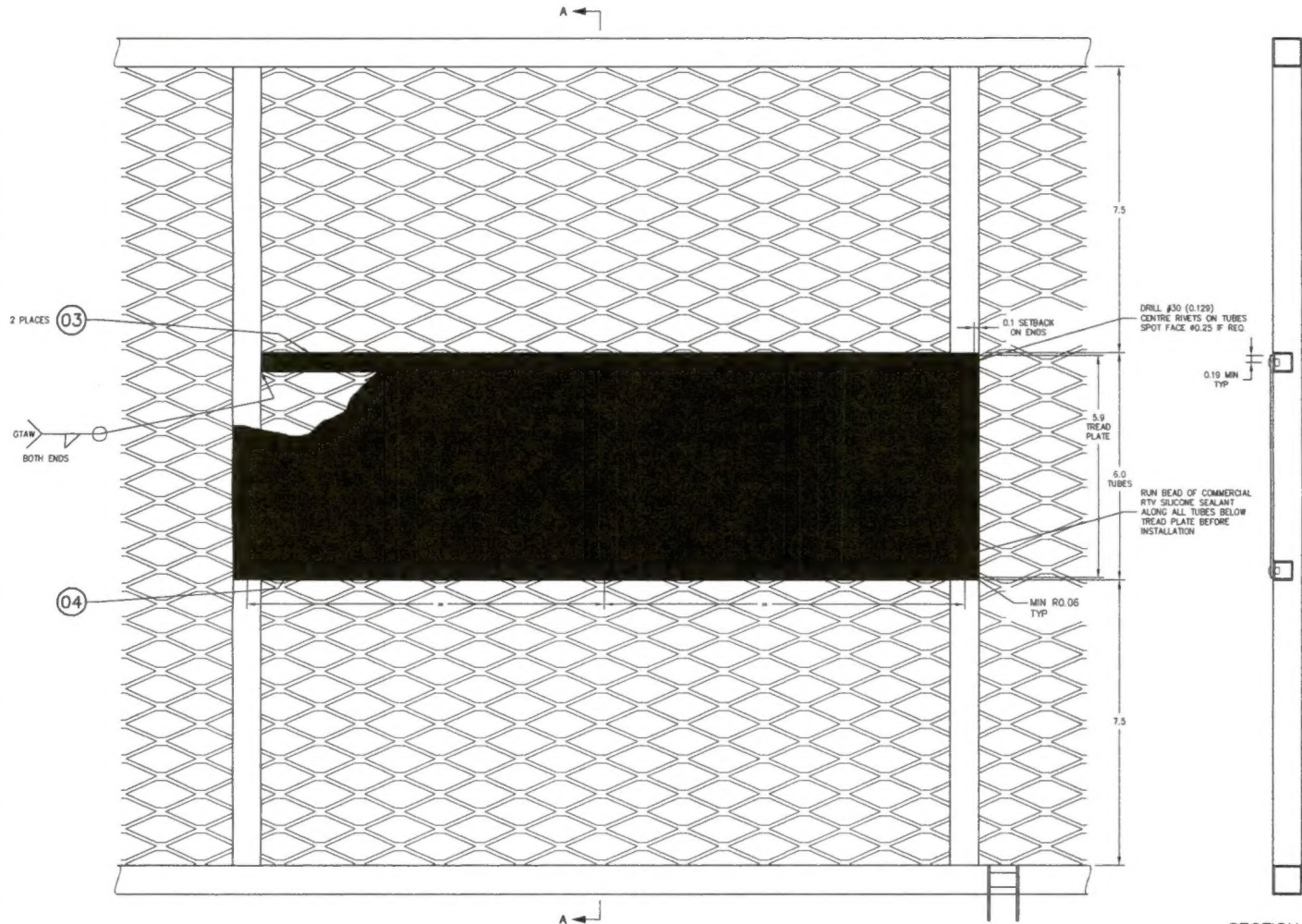
SCALE 1 : 1



AERO DESIGN LTD.			
9888A MALASPINA ROAD			
POWELL RIVER, BC, CANADA, V8A 0G3			
TEL: 604-693-5979			
www.aerodesign.ca			
BELL 407, 206L SERIES			
QUICK RELEASE HIGH MOUNTED CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
A1	76610	1	
SHEET 1 OF 1			



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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS; CHANGE TUBES	BJC	MAR 16/08
2	ADD EUROCOPTER EC135; MCCONNELL DOUGLAS MD500; BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014



01 BASKET LID ASSEMBLY

SECTION A-A

NOTES:

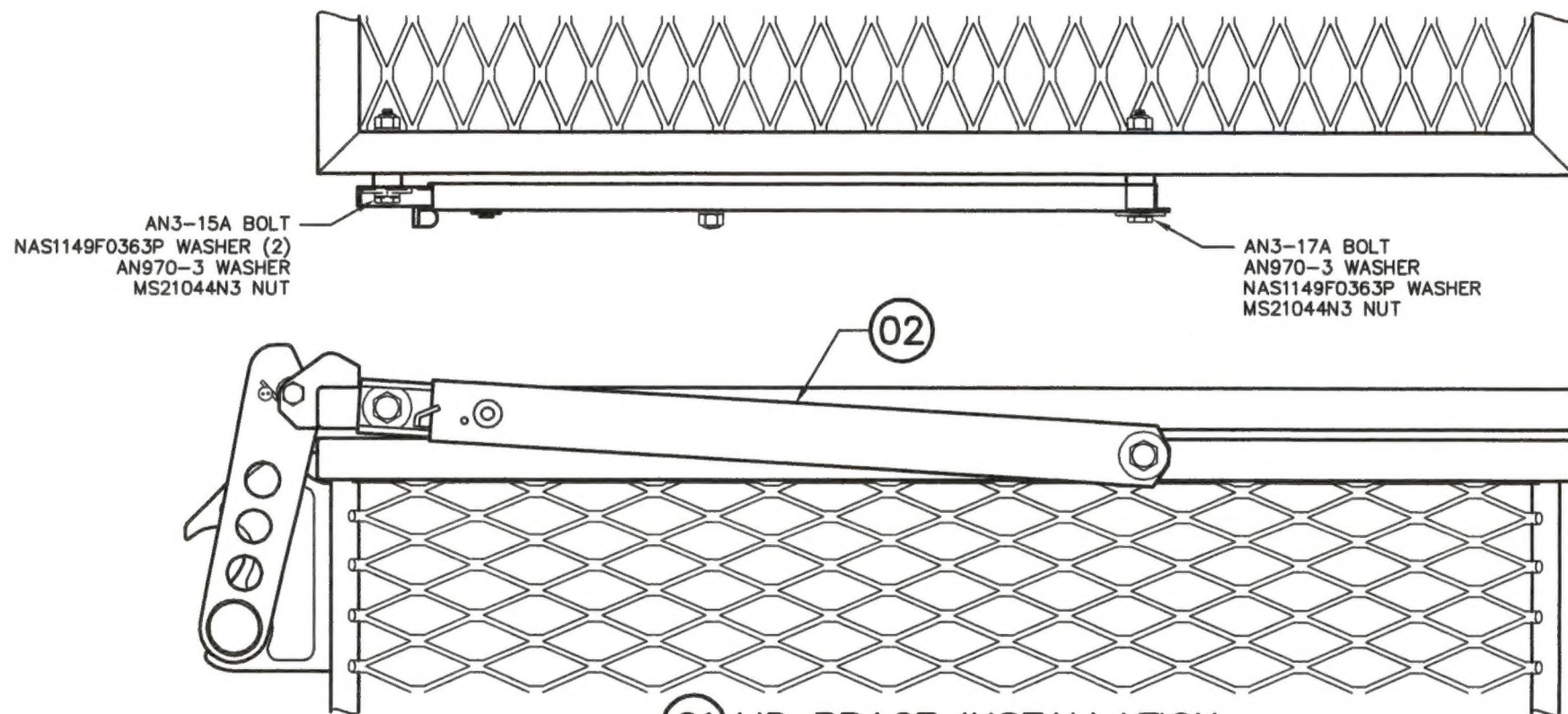
1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2689C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02	
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-8736 0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02 BASKET LID ASSEMBLY		
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP		
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
				MATERIAL SPEC
				STOCK SIZE

BASIC CODE REF. HAS 323 C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER H=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH + INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURCOON DATE: 21 SEPT 2006		AERO DESIGN LTD. 6888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.480.2376 www.aerodesign.ca	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARH=CR3213 ARH=CR3212				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS: X.XXX ±0.010 X.XX ±0.03 X.X ±0.1 ANGLES: ±1/2°		CARGO BASKET LID STEP MODIFICATION	
SCALE 1:1.5 SHEET 1 OF 1				DWG SIZE: A1 DWG NO: 70405		REV: 4	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## 01 LID BRACE INSTALLATION

### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT	APPROVALS		DATE			<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.489.2976      www.aerodesign.ca			
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE		21 MAY 2014						
2	AN970-3		WASHER	CHECKED: JASON REKVE		21 MAY 2014						
1	AN3-17A		BOLT									
1	AN3-15A		BOLT						<b>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</b>			
1	36280-01	02	LID BRACE ASSEMBLY									
	84240-01	01	LID BRACE INSTALLATION									
01	PART NO.	ITEM	DESCRIPTION	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2" X.XX ±0.03 X.X ±0.1		NOT TO SCALE		DWG. SIZE	DWG. NO.	REV.		
QTY.	LIST OF MATERIALS					SHEET 1 OF 1		A4	84240	0		



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - 76625		
1	DWG # CHANGED TO 76627; UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO	BJC	09/08/2016
	MAT'L THICKNESS CHANGED; P/N ADDED		


#### NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "BELL 206L SERIES & 407" - 0.080 HIGH  
 "P/N 76610-01 S/N 76601-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "200 LBS. TOTAL" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH  
 "www.aerodesign.ca" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



01 PLACARD

1	76627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.05 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
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			DRAWN: JEFF CLARKE	09 AUG 2016		
			CHECKED: JASON REKVE	09 AUG 2016		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE HIGH MOUNTED CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A1	76627	1

Work Order: 2017-198

Date Opened: 17 Nov. 2017

Material Tracking Sheet  
Bell 206L / 407  
HIGH Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		76610-01	<b>Cargo Basket Assembly</b>		S/N 76601-30
<b>Step 1</b>				<i>Lid Assembly</i>		
	1		76612-01	Basket Lid Assembly		2017-163-05
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	See PDS
	A/R		--	Sealant	Commercial Silicone RTV sealant	N/A
Step 1.b.	1		76627-01	Placard	0.050 Sheet, 6061-T6 Aluminum	CB SHN 76601-30 2015-03
	4		CR3213-4-02	Cherry Rivet		17070
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	17081
	A/R		CR3213-4-02	Cherry Rivet		17070
	A/R		--	Sealant	Commercial Silicone RTV sealant	N/A
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	1		76611-01	Basket Body Assembly		2017-163-05
	4		96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
	8		NAS1149F0663P	Washer		See PDS
<b>Step 3</b>				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	17017
	8		CR3523-5-02	Cherry Rivet		16063
	A/R		CR3213-5-02	Cherry Rivet		16053
<b>Step 4</b>	1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2017-50
	4		AN3-11A	Bolt		See PDS
	8		NAS1149F0363P	Washer		See PDS
	4		MS21044N3	Nut		See PDS

17 Nov 17  
rev 1



Work Order: \_\_\_\_\_

## Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: \_\_\_\_\_

## HIGH Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		84280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	

17 Nov 17  
rev 1

## Aero Design

### Parts Distribution Sheet

Description: Basket Assembly Kit

197 CB  
WO# 2017-198

[illegible]





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Lid No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76612-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-05

Remaining Tasks to be Performed: Clean up, Inspect,  
Powder coat.

Signature: David Martz

Date: Nov 3/2017 Lic. No. / SCA 73-04  
05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 H.M. Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76611-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-05

Remaining Tasks to be Performed: Clean up, inspect,  
powder coat.

Signature: [Signature]

Date: Nov 14/2017 Lic. No. / SCA AD 73-04 05

In Process



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0425</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-197</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket Ass'y</b>	8. Part Number <b>76610-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>76601-30</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>[Signature]</i>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mmm/yyyy) <b>22 Nov 2017</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*ALPINE HELICOPTERS*

# CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-197

Date Open: 17 Nov. 2017

## General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid	Lid	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l	Walk	Prop	Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	<a href="#">80210</a>	<a href="#">80227</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	<a href="#">80310</a>	<a href="#">80327</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	<a href="#">81110</a>	<a href="#">81127</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 206L/407 – Right side only									
	Low Standard	<a href="#">69810</a>	<a href="#">69827</a>	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Low Wide	<a href="#">94510</a>	<a href="#">94527</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Low Ski	<a href="#">94610</a>	<a href="#">94627</a>	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	High Ski	76610	76625	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell Medium – left or right									
	Standard	75110	75127	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Extra Large (ski)	95510	95527	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Mega	100610	100627	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Standard – Post S/N 71	95950	95927	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
	Medium	76410	76427	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Long	78410	78427	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
	Ski	94010	94027	<a href="#">Mat'l</a>					<a href="#">Mat'l</a>
Robinson R44 – left or right									
	Standard	90610	90627	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>
MD600									
	Standard	82810	82827	<a href="#">Mat'l</a>	<a href="#">70405</a>	<a href="#">84240</a>	<a href="#">84255</a>	<a href="#">84261</a>	<a href="#">Mat'l</a>

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).



## 1. Lid Assembly

### a. Install lid bumpers on bottom.

- i. Drill  $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

### b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

### c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
  1. 0.25" from edge of tread plate, centre on cross members (0.38")
  2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using  $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

### d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

## 2. Body Assembly

### a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
  1. 90610 (Robinson R44) basket only:
    - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
    - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
- Locate sheet on basket.
  - Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
  - Remove sheet and de-burr holes in sheet and rim.
  - Apply bead of RTV silicone sealant along all tubes under sheet. N/A
  - Locate sheet on basket, and cleco in place.
  - Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
- Locate sheet on basket. Ensure sufficient clamps are in place.
  - Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
  - Remove sheet and de-burr holes in sheet and rim.
  - Apply bead of Pro-Seal sealant along all tubes under sheet. N/A
  - Locate sheet on basket, and cleco in place.
  - Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation




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- a. Prepare hinge.
- Cut hinge to length:
    - 776, 906 – 54"
    - 751, 803 – 70"
    - 698, 764, 945 – 72"
    - 766, 784 – 90"
    - 940, 946, 959 – 95"
    - 1006 – 107"
  - Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
- Locate hinge on basket (standard baskets)
    - centre fore/aft
    - 0.15" – 0.18" up from bottom edge
  - Locate hinge on basket (extra wide baskets)
    - centre fore/aft
    - set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - Remove hinge and de-burr holes in hinge and basket rim.
  - Cleco hinge to basket with 5/32 clecos.
  - Install hinge with CherryMax rivets
    - CR3523-5-02 monel rivets – last 2 rivets in each end
    - CR3213-5-02 aluminum rivets – all other locations



- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

- a. Install handle brackets.
  - i. Set 84267-01 handle bracket on provisions in hoops, 2 places. 
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
  - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly. 
  - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
  - i. Operate handle to ensure handle does not bind and springs hold handle in. 
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.



*AK*

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

*N/A*

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7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.